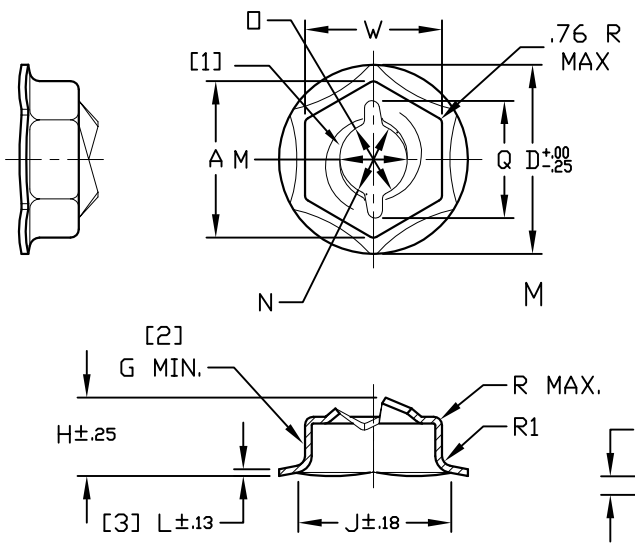


DWG SF080020

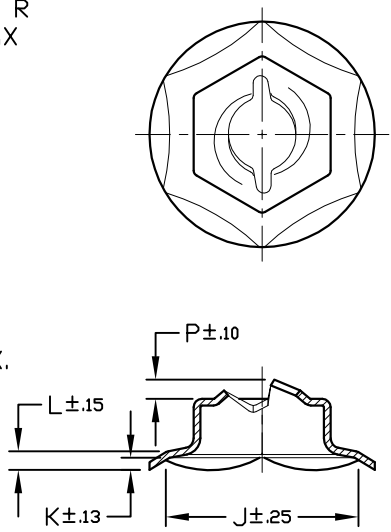
Référence
138 802 005
Matière : Acier Zingué
(CS-Zn)

<http://www.cergy-vis.fr>
[CERGY-VIS]
 ET SI ON PARLAIT SERVICE

DESIGN #1

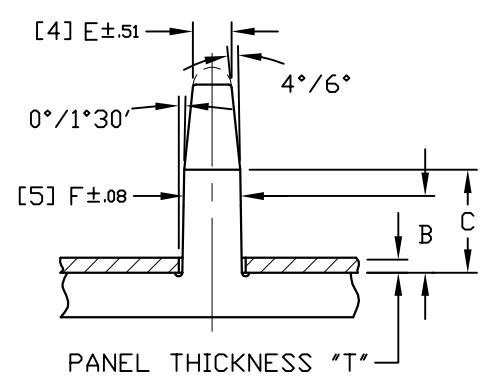


DESIGN #2



ASSEMBLY EFFICIENCY DEPENDS ON ADHERENCE TO STUD SPECIFICATIONS

DIE CAST STUD



- [1] FORMED HOLE M, N, O (M, O PERPENDICULAR TO HEX FLATS, N AT TIPS OF TEETH)
- [2] FLAT HEIGHT AT CENTER OF HEX. MAX TAPER 1° PER SIDE.
- [3] TOTAL DISH HEIGHT TO BASE RADIUS.

- [4] ROUND END OPTIONAL.
- [5] DIA. OF STUD INCLUDING PLATING AT HT. 'B'
- 6. TO ASSURE ADEQUATE STUD PROJECTION AND PROPER INITIAL THREADING, INCREASE LENGTH 'C' BY THE AMOUNT REQUIRED FOR UNCOMPRESSED GASKETS OR ANTICIPATED MISMATCH OF TRIM CONTOURS.
- 7. DIE CAST STUDS: NICKEL-CHROMIUM PLATING MUST NOT EXCEED .08 THICK ALONG STUD.
- 8. STUDS FABRICATED FROM WIRE: SURFACE HARDNESS MUST NOT EXCEED ROCKWELL B 80.
- 9. STEEL STUDS: NICKEL, CHROMIUM, OR OTHER HARD FINISHES ARE NOT RECOMMENDED.
- 10. WHEN NUT FINISH IS PHOSPHATE AND OIL, MINIMUM TIGHTENING TORQUE WILL BE 850F FIGURES.

* CONDITIONS OF ASSEMBLY PERFORMANCE:
 NUT TORQUED BY HAND ON PLAIN, COLD DRAWN STEEL STUD (HARDNESS R30T 74-82) AGAINST PLAIN STEEL WASHER (HARDNESS R30T 78-82).

NOMINAL STUD SIZE "F"	PALNUT PART NO.	CUSTOMER PART NO.	DESIGN NO.	HEX					WASHER				H	M	N	O	P	Q	STEEL THICK.	STUD DIMENSIONS			* ASSEMBLY PERFORMANCE ON COLD DRAWN STEEL			
				W	A	G	R	R1	D	J	K	L								B	C Min.	E	MAX. THRDG. TORQUE Nm	TIGHTENING TORQUE Nm	MIN. CLAMPING N	MIN. ULTIMATE TORQUE Nm
8.0	SF080020		2	13.00/12.80	15.02/14.50	2.75	1.14	0.96	20.00	16.30	0.71	1.17	7.85	7.34/7.19	7.34/7.16	7.98/7.72	1.65	10.06/9.55	0.58	T+7.3	T+10.0	5.60	5.65	11.30	1335	11.86

DATE	REV	DESCRIPTION	BY
8/1/00	A	REDRAWN TO AUTOCAD 2000	M.S.
7/30/99		MOVED 'P' LOCATION TO LOW TOOTH REMOVED 'P' NOTE 1.52 (P) DIM WAS 1.14 PER ECD0022	K.J.D.
6/4/98		.71 WAS 1.09 (SF080020) PER EC #1890	B.A.D.
6/12/95		REDRAWN TO CAD; NO CHANGES	B.A.D.
5/22/88		12.70/12.26 WAS 12/70/12.76	W.S.
1/18/88		RELEASED SF080020 RELEASE #1161	W.S.
5/7/86		ADDED SF080032 FROM DWG.8-28/75 SUPERCEDED	J.L.
10/21/82		'M' WAS 5.57/5.89, 'N' WAS 5.58/5.77, 'O' WAS 6.17/6.35 ON SF630015, SF630018, SF630021 & SF630024	B.A.D.
4/6/81		ADDED PART #SF060015	J.T.
6/7/79		CORRECTED M,N,O DIMS ON SF060018; ADDED NONRELEASED PART SF060020	E.R.N.
12/3/78		ADDED SF060018	R.S.
5/5/78		REDRAWN-REPLACES COPY DATED 11/23/77	J.M.K.

A Raymond TINNEMAN

MATERIAL:
 50 CARBON SPRING STEEL

HARDNESS: ROCKWELL 30N 60-70

TOLERANCES, UNLESS SPECIFIED:
 mm ±.25 in ±.010

PAL® PALNUT® ON SERT® PUSHNUT®

TITLE
 PALNUT SELF THREADING NUTS,
 WASHER TYPE
 STYLE 'SF', METRIC

DRAWN: D.A.	RELEASED	SCALE
DATE: 5/15/78	PART No: SF080020	NONE
CHECKED:	DWG No.	SF080020
APPROVED:		